

Work Order ID 74311

Wednesday, September 28, 2011 11:38:00 A

Page 1

Item ID: D3697-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Tube Assembly

Start Date: 9/28/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan: M.L.J

Date: 9/29/11 Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3697

Rev B

100

0.00



Small Fab

Small Fab

Memo 22.00"

0.00

Small Fab

Made in
Seq 130

1- cut at 6.00" as per dwg D3697 12- form and trim tube as per dwg D3697
using DT9003 13-deburr

EL 12-2-27 (X2)

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

N/A

120

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

EL 12-2-27 (X2)

W/O:		WORK ORDER CHANGES					
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Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Large Fab

Large Fab

Memo

0.00

1-weld D3697-3/-4 and D3797-1 on tube D3697-1 as per dwg D3697 using
DT9003 welding jig! 12-drill holes in tube in 5 pls as per dwg D3697

EZ 12-2-27 (X)

140

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

2 0 BE12-02-28

150

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

S12/02/28

(72)

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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

2-2-29
m

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

24 6 11/01/11

180

Identify as per dwg & Stock Location: 24/B 0.00



Packaging

Memo

0.00

Packaging

24/B 11/01/11

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Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

12/3/5

MCJ 12/03/03
(2)

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Picklist Print

Page 1

Wednesday, September 28, 2011 11:37:57 AM

Work Order ID: 74311

Parent Item: D3697-041

Parent Item Name: Tube Assembly

Start Date: 9/28/2011

Required Date: 10/14/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-04-25 new issue DD verified by:EC
IPP Rev:B 08-07-14 revB as per dwg DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3697-3 Manufactured No



Support Plate, LH

Location

WA023

Loc Qty

7

Loc Code

50386

7

100

Each

7.0000

1

4



EL 12-2-24

D3697-4 Manufactured No



Support Plate, RH

Location

WA023

Loc Qty

7

Loc Code

59681

7

130

Each

0.0000

1

4



EL 12-2-24

D3797-1 Manufactured No



Ground Plate

M6061T6T0.375W.049

Purchased

74313

No

130

f

40.0000

6

25.26316



EL 12-2-27

6061-T6 RD Tube .375 x.049W

Location

MAT014

Loc Qty

40

Loc Code

109000

16

116720

24

121

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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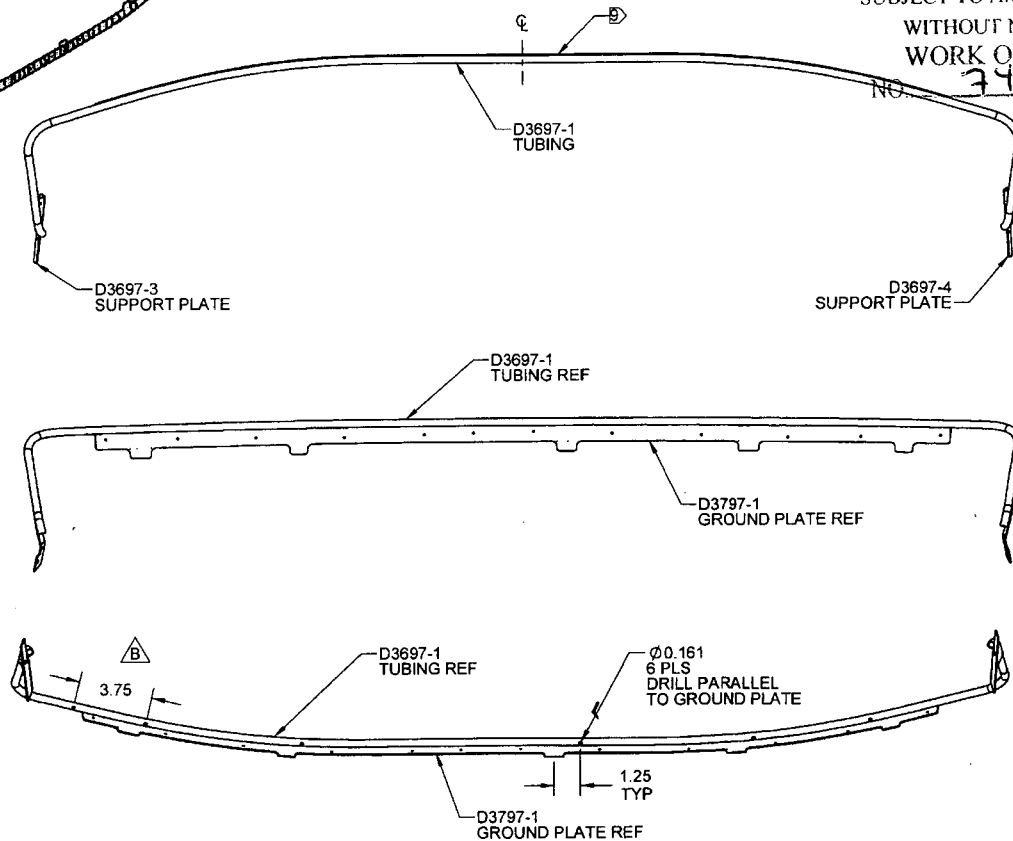
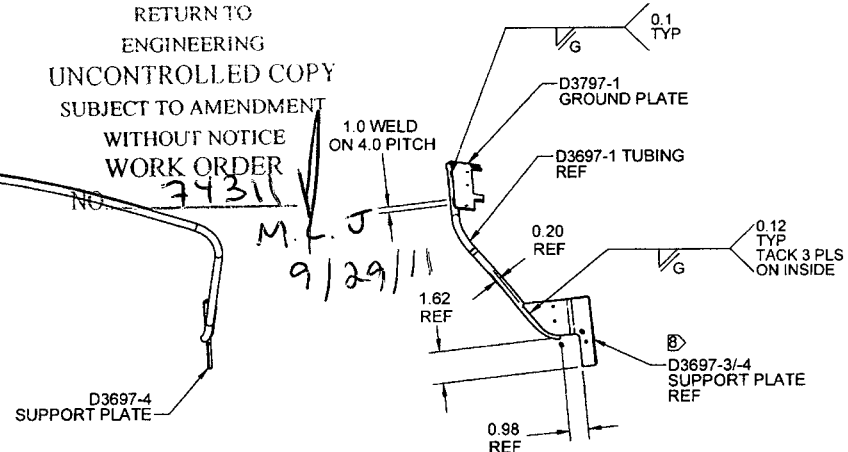
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74311

M.F.J.
9/29/11



- NOTES:
- 1) WELD PER QSI 004
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.55 lbs
 - 8) LOCATE D3697-3/-4 ON D3697-1 USING DT9009 WELDING JIG
 - 9) CENTER D3797-1 GROUND PLATE ON D3697-1 TUBING

D3697-041 TUBE ASSEMBLY

PART LIST

QTY	PART NUMBER	DESCRIPTION
X	D3697-041	TUBE ASSEMBLY
1	D3697-1	TUBING
1	D3697-3	SUPPORT PLATE
1	D3697-4	SUPPORT PLATE
1	D3797-1	GROUND PLATE

B	REMOVE POWDER COAT & MASKED HATCHED AREAS. SHEET 1 ZONE A,B, ADD Ø0.161 HOLE. SHEET 1 ZONE B,7	RF	08.06.02
A	NEW ISSUE	RF	08.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.06.02		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3697** REV. B
SHEET 1 OF 3
TITLE **TUBE ASSEMBLY** SCALE NTS

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W/O:		WORK ORDER CHANGES					
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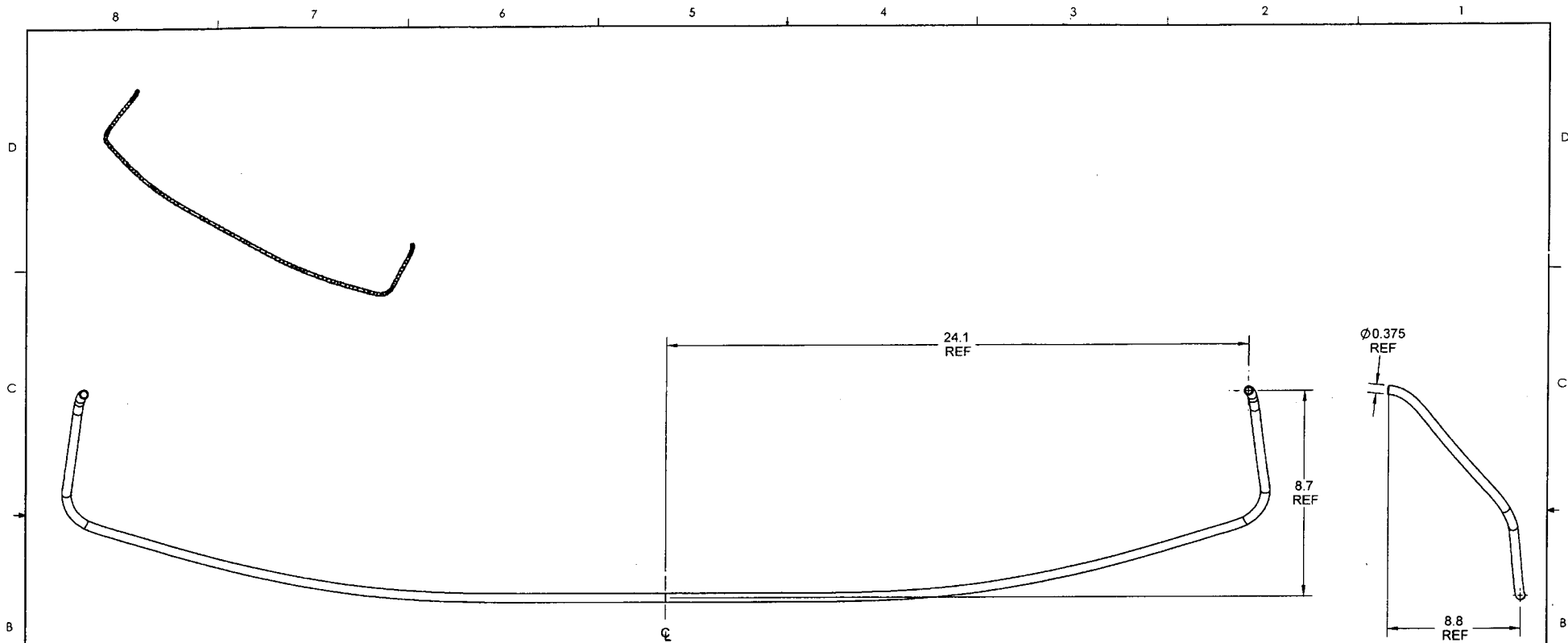
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74311



D3697-1 TUBING

RELEASED
06.03.06

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 (VW-T-700/6) ALUMINUM TUBING $\varnothing 0.375 \times 0.049$ WALL
(REF. DART SPEC. M6061T6T0.375W0.049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lb
- 8) FABRICATE USING TEMPLATE DT9003

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3697	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 3	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TUBE ASSEMBLY	NTS
DATE	08.06.02	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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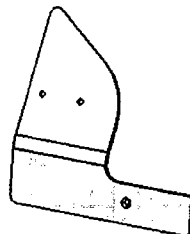
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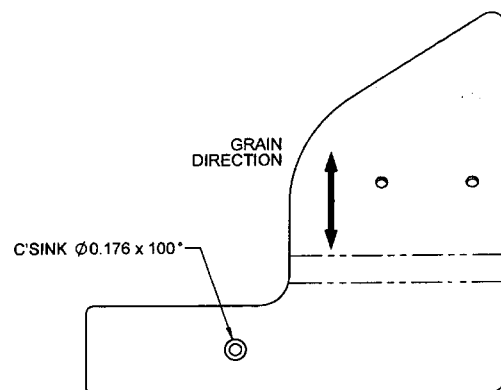
74311



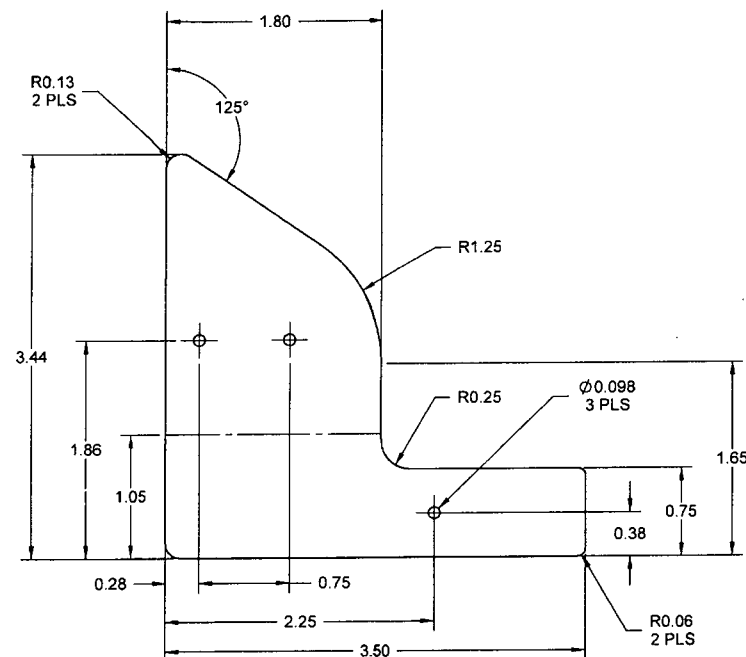
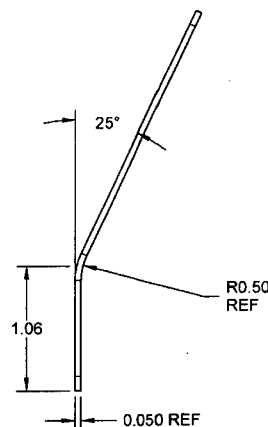
D3697-3 SUPPORT PLATE (LH SHOWN)



D3697-4 SUPPORT PLATE (RH SHOWN)



**D3697-3 SUPPORT PLATE (LH SHOWN)
(D3697-4 SUPPORT PLATE OPPOSITE)
(MAKE FROM D3697-3F FLAT PATTERN)**



D3697-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) SHEET 0.050 THICK (REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. B
MFG. APPR.	JP	D3697	SHEET 3 OF 3
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	TUBE ASSEMBLY	NTS
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